














Tap M12 HM Z3

A10-020

In the manufacturing cycle is included the dressing cycle for the profile wheel, which needs to be dressed actually all 10 cycles. The diamond wheels have got an aluminium body so that there is no need for a balancing unit.



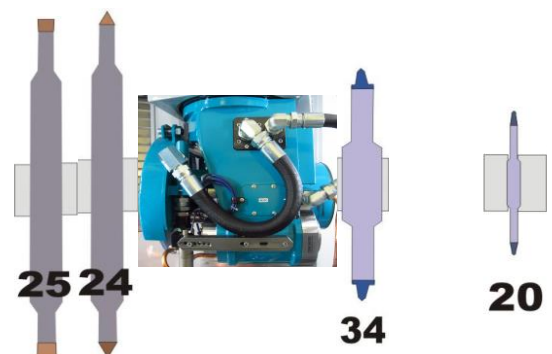
1. Cycletime for Production

Tool specifications M12, Length 22mm, flutelength 46, Helix 30° Material HM							
Operations							
	Charging	Flute	Thread rough	Thread fine	Tip cutting	Tip cutting+ Chamfer	dress thread
Feed [mm/Min]		60	200	4600	500	4000	100
Power [kW]		6	4	1	2	2	1
Cutting feed [m/s]		19	22	22	23	23	14
Used wheels							
		34	24	24	25	25	20
Grinding time [s]	20	223	193	24	73	30	157
Total cycle time	12 Min						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

24 Ø400 DXF D121
25 Ø404 1V1 D121
34 Ø175 14F1 D121
20 Ø125 14EE1 D301



3. Machine and Software Requirements

Machines: 6 axes CNC grinders : TAP NGM, dressing unit
Control: Fanuc 31i B5
Coolant: Synthetic Oil, pressure 14-16 bar
Software: Quinto 5.4.6

responsible engineer: FFR,09.01.15

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